

S212711

DART
AEROSPACE
DAS-81

P/N: D5085-1

REV: A

SERIAL: S212711

SEP 11 2019

DAS

INSP/DATE:

81

9-89

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
CanadaTel (613) 632-5200
Fax 613 632-5246

D5085-1

Job Sheet 199296



D5085-1

Web



lbs

Job Qty: 2 pcs

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 14-10-27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Purchasing <i>Wagay</i>	2		8/30/19	0.00	0.00	Purchasing - 1		
		pcs					Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2		8/30/19	0.00	0.00	Packaging 2 - 1 - B4B		
		pcs					Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		

DART
AEROSPACE

Container No: S212711



Part: D5085-1

Job No: 199296

Serial No/Batch: S212711

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/11/19

Plex 8/16/19 1:06 PM Dart.lajeunesse.marie

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	2 pcs	8/30/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
130	Handfinish - 1-1 Chemical-B4B	2 pcs	8/30/19	0.00 1.06	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140	QC 7	2 pcs	8/30/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	

					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
150	Packaging 3-1 - Stock - B4B	2	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
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					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
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					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160	QC 21 - SA	2	8/30/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs				QC 21 - SA - 70	21
					QC 21 - SA - 53	9-69

Part Op 100 - Purchasing Machine as per Dwg D5085
 Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)

- 130** - (Chemical Conversion Coat per QSI005 4.1)
140 - (QC7-Inspect Chemical Conversion Coat)
150 - (Identify as per dwg & Stock Location: _____)
160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5085-1P	Web	62 pcs (1 ea)	100-Purchasing	S212651
D5086-1-112	Extrusion 112" Long	62 pcs (1 ea)	100-Purchasing	E146176
				S208769

Job Allocations

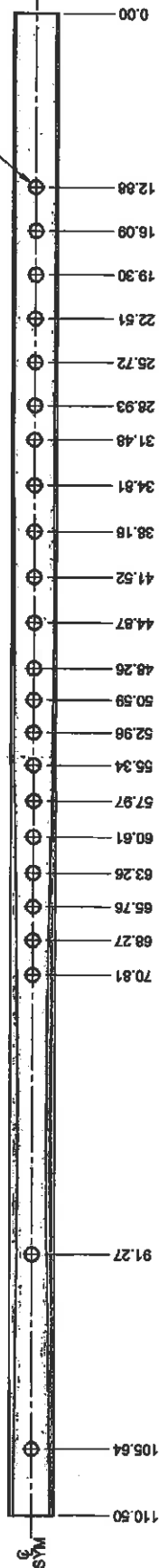
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D5085-1P	26	0	0
	<u>D5086-1-112</u>	26	42	0

Part Specifications

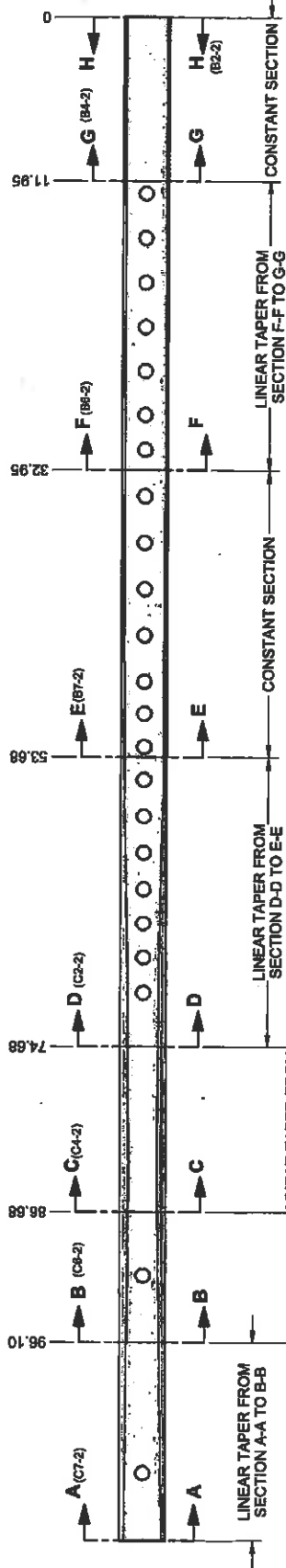
Specifications could not be found.

Plex 8/16/19 1:06 PM Dart.lajeunesse.marie

Ø1.00
23 PL



110.5
REF



D5085-1 WEB

RELEASED
2015-06-08
EW 45-537

A		NEW ISSUE		DESCRIPTION		AP		BY		DATE	
REV.	DESIGN	DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.	DATE	AP	BY	DATE	
	D5085	DW	JLM	HS	DE	15.02.25					
DART AEROSPACE USA, INC.											
KENT, WA											
DRAWING NO. D5085											
REV. A											
SHEET 1 OF 2											
TITLE: WEB											
SCALE											
NTS											

APPROVED

UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE

199296 MLS
190816

- NOTES:
- 1) MATERIAL: MAKE FROM D5086-1-112 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI044 METHOD 6.1
 - 7) WEIGHT: 14.79 lbs

199296 MLS
190816

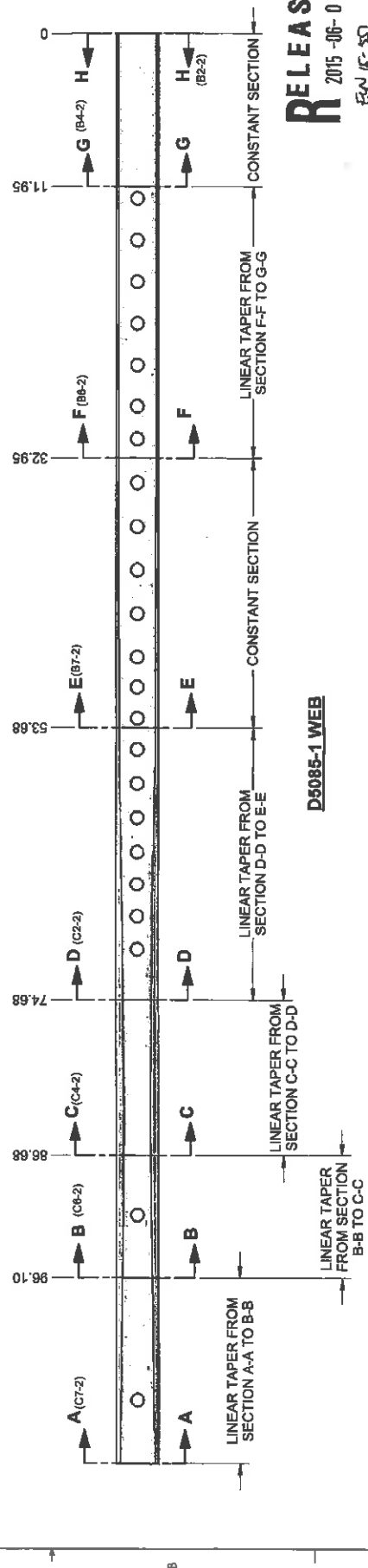
Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS																																																																															
		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																									
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)																																																																													
Description Work Order Deviation				Disposition																																																																															
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>				Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>☐</td><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Bending</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>Crushing</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Mislabeled</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr></table>								Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐																																																																														
Other/Details:																																																																																			
				Completed By																																																																															
				Lead hand / Supervisor																																																																															
				QC / QA Coordinator																																																																															



RELEASED
2015-06-08

2015-06-08

2015-05-25

A	NEW ISSUE	DESCRIPTION		AP	15.02.25
REV.				BY	DATE
DART AEROSPACE USA, INC. KENT, WA					
DESIGN	AP	DRAWING NO.		REV. A	
DRAWN	AP	D5085		SHEET 1 OF 2	
CHECKED	DW	JLM		TITLE	SCALE
MFG. APPR.		HS		WEB	NTS
APPROVED		DS			
DE APPR.					
DATE		15.02.25			
COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS LOANED TO YOU BY DART AEROSPACE USA, INC. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE USA, INC.					

APPROVED

NOTES:

- 1) MATERIAL: MAKE FROM D9986-1.112 EXTRUSION
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 METHOD 6.1
- 7) WEIGHT: 14.79 lbs



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044307



Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: POHB044307
PO Date: 8/22/19
Due Date: 9/20/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
2019-8-22

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199296	D5085-1P	for 6 pcs		Web as per Dwg D5085 RevA	Firmed	-	9/20/19	6 pcs	0 pcs	6 pcs	\$1,050.00/pcs	\$6,300.00
Grand Total:													\$6,300.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/22/19 9:06 AM Dart.Guerin.Kimberley

WEJAY MACHINE PRODUCTS COMPANY LIMITED
800 O'CONNOR DRIVE
KINGSTON, ON, CANADA K7P 1N9
TEL: 813-384-1682 FAX: 813-384-2897
WEJAY.COM



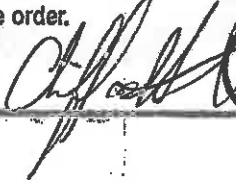
S Dart Aerospace
O 1270 Aberdeen Street
L Hawkebury ON K6A 1K7

SH-6
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

SOLD TO

STRAIGHT

INVOICE DATE	YOUR ORDER NO. PCRB044307	DATE ORDERED 08/22/19	SHIPPED VIA Best way
CUSTOMER CODE 10001	PROV. LIC. NO.	Extra ☐ Exempt ☐	TERMS

QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION	UNIT PRICE	AMOUNT
6	0	6	Web as per drawing D5085, Rev. A Dart part number: D5085-1P Job number: 199296 Required by: September 20, 2019 RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor  		DAS 81 9-89

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION

RECEIVED BY _____
 .5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: Sept 9, 2019	
		P.O.# POHB044307	
		WEJAY JOB# 39645	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D5085-1P 'Web' w/o# 199296	6	Machined supplied extrusions complete per drawing req'ts	D5085 / rev. A
Note: 1) Material supplied by Dart Aerospace. ref DART s/n B146176. 2) 1st Article Inspection Report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 39645

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# POHB044307

PART No. D5085-1P

DESCRIPTION: Web

DWG No. D5085 - sheets 1-2

REV. A

E.C.O. --

MATERIAL: Extrusions supplied by DAS
DART SCN: B146176

INSPECTOR:
Cliff Smith



QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
-

N.C.R.#
-

DATE: Sept. 3, 2019

INSTRUCTIONS, COMMENTS: **FIRST ARTICLE INSPECTION** / FINAL INSPECTION

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	110.5	O.A. length	±.03	1_C4	110.500	1	Accepted
2	Hole, Diameter 1.00	23 places	+ .010/- .001	1_D1	Ø 1.003- 1.004	1	Accepted
3	12.88		±.03	1_D2	12.880	1	Accepted
4	16.09		±.03	1_D2	16.089	1	Accepted
5	19.30		±.03	1_D2	19.298	1	Accepted
6	22.51		±.03	1_D2	22.507	1	Accepted
7	25.72		±.03	1_D3	25.716	1	Accepted
8	28.93		±.03	1_D3	28.926	1	Accepted
9	31.48		±.03	1_D3	31.475	1	Accepted
10	34.81		±.03	1_D3	34.805	1	Accepted
11	38.16		±.03	1_D3	38.155	1	Accepted
12	41.52		±.03	1_D4	41.515	1	Accepted
13	44.87		±.03	1_D4	44.866	1	Accepted
14	48.26		±.03	1_D4	48.262	1	Accepted
15	50.59		±.03	1_D4	50.584	1	Accepted
16	52.96		±.03	1_D4	52.963	1	Accepted
17	55.34		±.03	1_D5	55.345	1	Accepted
18	57.97		±.03	1_D5	57.971	1	Accepted
19	60.61		±.03	1_D5	60.610	1	Accepted
20	63.26		±.03	1_D5	63.262	1	Accepted
21	65.76		±.03	1_D5	65.759	1	Accepted
22	68.27		±.03	1_D5	68.269	1	Accepted
23	70.81		±.03	1_D6	70.812	1	Accepted
24	91.27		±.03	1_D7	91.274	1	Accepted
25	105.64		±.03	1_D8	105.646	1	Accepted
26	Sym to centerline		±.03	1_D8	Passed	1	Accepted

SECTION A-A

27	110.5	Loc'n of section	±.03	1_C7	110.500	1	Accepted
28	2.750	2 pl.	+ .010/- .030	2_D7	2.748- 2.749	1	Accepted

INSPECTION / TEST REPORT					JOB No.		
					PAGE: 2 of 3		
CUSTOMER: Dart Aerospace							
CUST. P.O PO							
PART No.D5085-1				DESCRIPTION: Web			
DWG No. D5085 - sheets 1-2				REV. A		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

29	R 0.25	4 pl.	±.03	2_D8	R .250 typ.	1	Accepted
30	1.60	2 pl.	±.03	2_D7	1.615- 1.618	1	Accepted
31	.240		±.01	2_D8	.239- .242	1	Accepted
32	R .06	4 pl.	±.03	2_C8	R .060 typ.	1	Accepted

SECTION B-B

33	96.10	Loc'n of section	±.03	1_C7	96.100	1	Accepted
34	2.381	2 pl.	+ .010/- .030	2_D5	2.382- 2.384	1	Accepted
35	R 0.50	4 pl.	±.03	2_D6	R .500 typ.	1	Accepted
36	1.89	2 pl.	±.03	2_D6	1.895 typ.	1	Accepted
37	.425		±.01	2_D6	.420- .424	1	Accepted
38	R .13	4 pl.	±.03	2_D6	R .130 typ.	1	Accepted
39	Linear taper	Sect. A-A to B-B	-	1_B8	Passed	1	Accepted

SECTION C-C

40	86.68	Loc'n of section	±.03	1_C6	86.680	1	Accepted
41	2.090	2 pl.	+ .010/- .030	2_D3	2.094 typ.	1	Accepted
42	R 0.25	4 pl.	±.03	2_D4	R .250 typ.	1	Accepted
43	2.20	2 pl.	±.03	2_D4	2.1995- 2.201	1	Accepted
44	.285		±.01	2_D4	.2875	1	Accepted
45	R .15	4 pl.	±.03	2_C4	R .150 typ.	1	Accepted
46	Linear taper	Sect. B-B to C-C	-	1_B7	Passed	1	Accepted

SECTION D-D

47	74.68	Loc'n of section	±.03	1_C6	74.680	1	Accepted
48	2.090	2 pl.	+ .010/- .030	2_D1	2.0825	1	Accepted
49	R 0.25	4 pl.	±.03	2_D2	R .250 typ.	1	Accepted
50	2.20	2 pl.	±.03	2_D2	2.195- 2.201	1	Accepted
51	.125		±.01	2_D2	.1275	1	Accepted
52	R .15	4 pl.	±.03	2_C2	R .150 typ.	1	Accepted
53	Linear taper	Sect. C-C to D-D	-	1_B6	Passed	1	Accepted

SECTION E-E

54	53.68	Loc'n of section	±.03	1_C5	53.680	1	Accepted
55	2.941	2 pl.	+ .010/- .030	2_B7	2.936- 2.9385	1	Accepted
56	R 0.25	4 pl.	±.03	2_B8	R .250 typ.	1	Accepted
57	1.41	2 pl.	±.03	2_C7	1.402- 1.404	1	Accepted
58	.125		±.01	2_B8	.125- .126	1	Accepted
59	R .030	4 pl.	±.01	2_B8	R .030 typ.	1	Accepted
60	Linear taper	Sect. D-D to E-E	-	1_B5	Passed	1	Accepted

INSPECTION / TEST REPORT						JOB No.	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO							
PART No.D5085-1				DESCRIPTION: Web			
DWG No. D5085 - sheets 1-2				REV. A		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

SECTION F-F							
43	32.95	Loc'n of section	±.03	1_C3	32.950	1	Accepted
44	2.941	2 pl.	+ .010/- .030	2_B5	2.941	1	Accepted
45	R 0.25	4 pl.	±.03	2_B6	R .250 typ.	1	Accepted
46	1.41	2 pl.	±.03	2_C6	1.406 typ.	1	Accepted
47	.125		±.01	2_B6	.127- .128	1	Accepted
48	R .030	4 pl.	±.01	2_B6	R .030 typ.	1	Accepted
49	Constant Section	Sect. E-E to F-F	-	1_B4	Passed	1	Accepted
SECTION G-G							
50	11.95	Loc'n of section	±.03	1_C2	11.9850	1	Accepted
51	3.000	2 pl.	+ .010/- .030	2_B3	2.999	1	Accepted
52	R 0.25	4 pl.	±.03	2_B4	R .250 typ.	1	Accepted
53	1.27	2 pl.	±.03	2_C4	1.264	1	Accepted
54	.125		±.01	2_B4	.1275	1	Accepted
55	R .030	4 pl.	±.01	2_B4	R .030	1	Accepted
56	Linear taper	Sect. F-F to G-G	-	1_B3	Passed	1	Accepted
SECTION H-H							
57	0.00	Loc'n of section	±.03	1_C1	0.00	1	Accepted
58	3.000	2 pl.	+ .010/- .030	2_B1	2.998- 3.001	1	Accepted
59	R 0.25	4 pl.	±.03	2_B2	R .250 typ.	1	Accepted
60	1.27	2 pl.	±.03	2_C2	1.269	1	Accepted
61	.125		±.01	2_B2	.128	1	Accepted
62	R .030	4 pl.	±.01	2_B2	R .030 typ.	1	Accepted
63	Constant Section	Sect. G-G to H-H	-	1_B1	Passed	1	Accepted

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: DS085-1
 DATE: SEP 11 2019

PO / BATCH NO.: POH8044307 /
S212651

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 6 pcs
 QUANTITY INSPECTED: 6 pcs
 QUANTITY REJECTED: -

THICKNESS ORDERED: as per DWG
 THICKNESS RECEIVED: "
 SHEET SIZE ORDERED: -
 SHEET SIZE RECEIVED: -

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	<u>DS085-1P</u>
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	
CORRECT MATERIAL IDENTIFICATION	☒ Y N	<u>POH8044307</u>
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>Valerie Miller</u>	DAS 81 9-89	SIGNED OFF BY: _____	
DATE: <u>SEP 11 2019</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in